

Date: Tuesday, 1/31/2006 11:07:10 AM  
 User: Kim Johnston

## Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 25689 -2  
 Estimate Number : 12132  
 P.O. Number : NIA  
 This Issue : 1/31/2006 S.O. No. : NIA  
 Prsht Rev. : NC  
 First Issue : NIA Type : SMALL /MED FAB  
 Previous Run : NIA  
 Drawing Name : BLOWER MOTOR ADAPTER  
 Part Number : D34763  
 Drawing Number : D3476 REV A  
 Project Number : N/A  
 Drawing Revision : A  
 Material : NIA  
 Due Date : 2/21/2006 Qty: 10 Um: Each  
 Written By : SEE COMMENT BELOW  
 Checked & Approved By : JF 06.01.31  
 Comment : Est Rev:A New Issue 06-01-31 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 489 For D3476-3S

Spin as per Dwg D3476

Possible Supplier: SIEG

Material release note is required

2.0 D34763S blower motor adapter



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
 scoop outlet

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

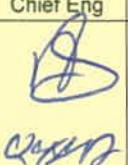
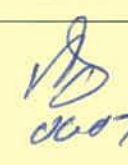
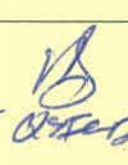

1-Layout Hole Position Using Dt8844 Template

2-Drill 2.250" as per Dwg D3476

JF 06.06.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 26/07/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/07/05		2 scrap		Scrap & destroy SB	06/07/05			

NOTE: Date & initial all entries



Date: Tuesday, 1/31/2006 11:07:10 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR ADAPTER

Job Number: 25689

Part Number: D34763

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Flare as per Dwg D3476 Using DT8845 A&B

4-Deburr if Required

FF 06.06.19

21

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/07/05

21

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: BA

SB 06/07/05

21

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SB 06/07/06

1

Job Completion



U 06.05.07

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

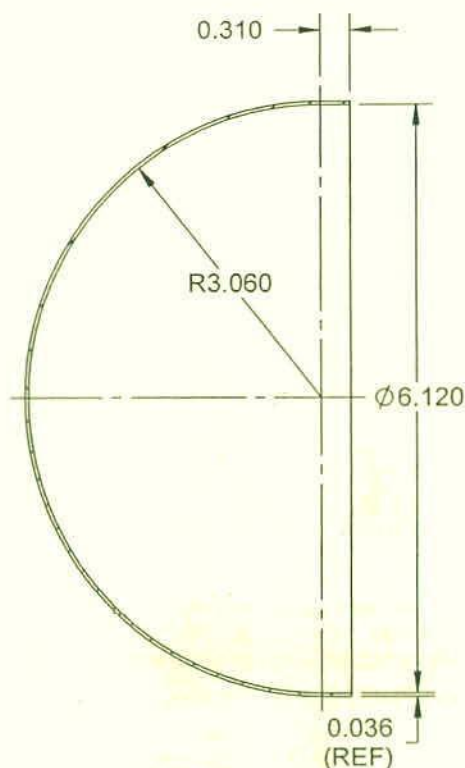
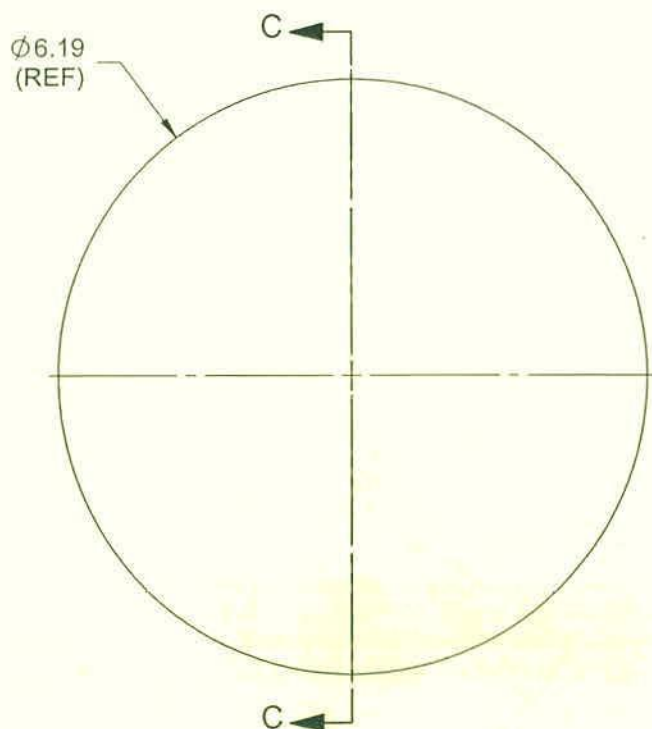
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PRELIMINARY ISSUE

DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3476	REV. A SHEET 4 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2



SECTION C-C

D3476-3S DOME, SPINNING DETAIL

NOTES:

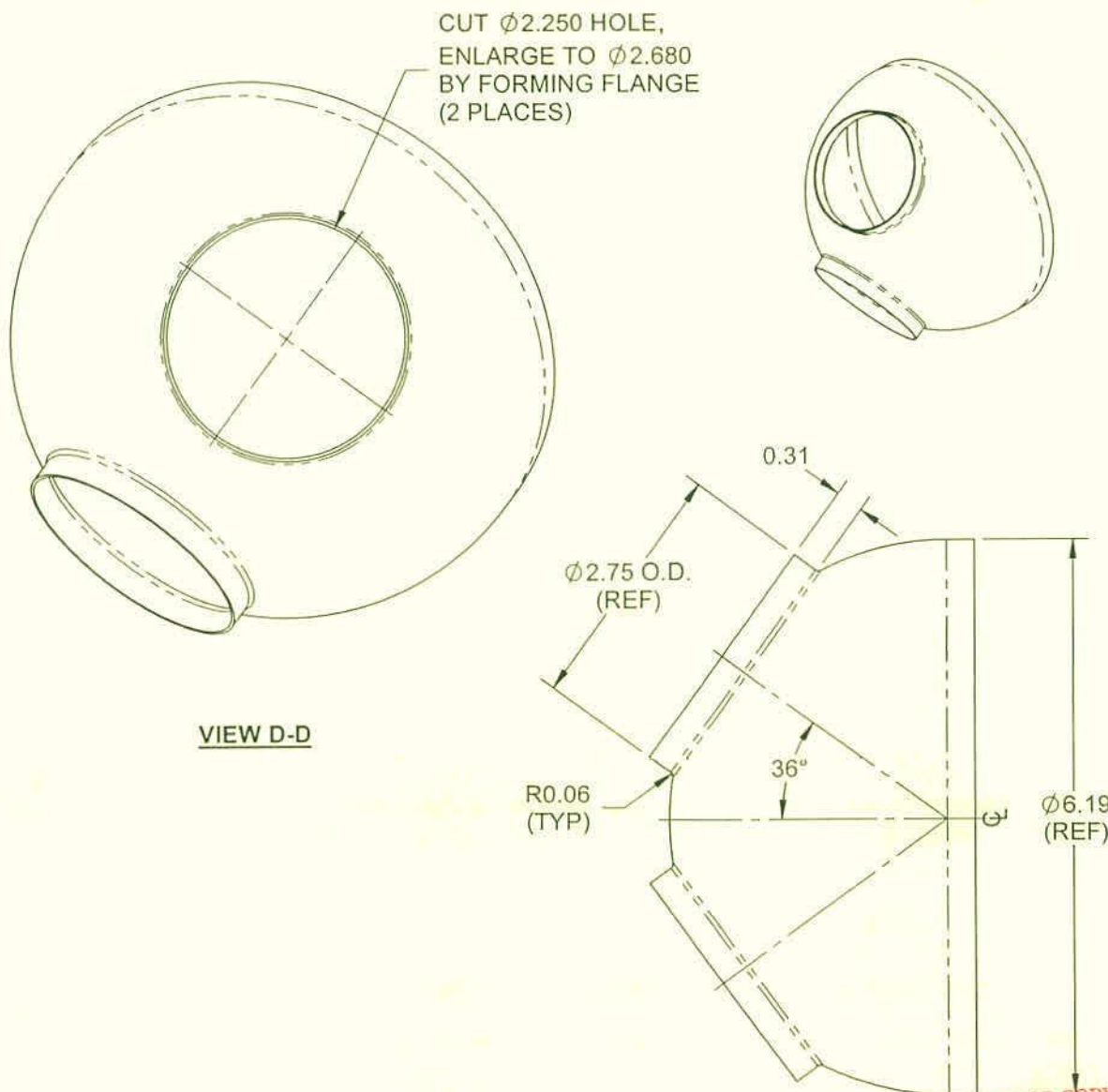
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)  
2B FINISH (REF. DART SPEC. M304S20GA)
- 2) FORM BY SPINNING TO DIMENSION WITHOUT EXCESS THINNING  
OF MATERIAL.
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 25689

where

PRELIMINARY ISSUE

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3476-3	REV. A SHEET 5 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2



**D3476-3 DOME**

**NOTES:**

- 1) MATERIAL: MAKE FROM D3476-3S
- 2) FINISH: NONE
- 3) PART IS SYMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER  
NO. 25689



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Cambridge, Mass.





Sieg's Manufacturing Ltd.

604 530-7455 fax 604 530-7490  
6236-205 Street, Langley, British Columbia, Canada. V2Y 1N7

## INSPECTION REPORT

DATE: Mar 10/06

CUSTOMER: Dart Aerospace Ltd.

INVOICE #: 2997 SUPPLIER #: \_\_\_\_\_

DESCRIPTION OF INSPECTION: D3476

P10485

2006.03.13

PART #	QTY.	MATERIAL	CHECK HOLES	DEBUR EDGES	INSP BY.
D3476	10	✓	N/A	✓	<u>[Signature]</u>

NOTES OF INSPECTION: good Now

NOTES OF REJECT: \_\_\_\_\_





/23/06 THU 14:14 FAX 6045209808  
Mill Test Report

ABSTRACT INT'L METALS

MILN: Arla

Page 1 of 1


## MILL TEST REPORT

TA CHEN INTERNATIONAL, INC.  
www.tachen.com

This MTR contains 1 page (Page: 1)

MTR#: ACCL10542

Item#: 20GA48120316L2B

 <b>ThyssenKrupp Nirosta</b> Ein Unternehmen von ThyssenKrupp Stahl AG		<b>ABNAHMEPRUEFZEUGNIS 3.1</b> <b>INSPECTION CERTIFICATE 3.1</b> <b>CERTIFICAT DE RECEPTION 3.1</b> EN 10204		Zeugnis-Nr.: 051101471 Certificate No.: N° du certificat: <i>ACCL10542</i> Datum: 20.04.2005 Date: Date:						
47704 Krefeld Postfach <b>THYSSENKRUPP NIROSTA</b> 2275 HALF DAY ROAD, SUITE 160 USA- BANNOCKBURN, IL 60015 USA		Besteller: Purchaser: Commandant: <b>THYSSENKRUPP NIROSTA</b> Bestell-Nr.: Order-No.: Commande N°: <b>OC 00002449 - PO L13812</b> Unser Auftrag Nr.: Our Order No.: Notre commande: <b>278140</b> Lieferungs-Nr.: Delivery Note No.: Avis d'expédition N°: <b>86437223</b> Zeichen d. Bestätigung: Inspector's stamp: Patroon de l'expert: <b>QA</b>								
Erzeugnisform: Product: Produkt: <b>Blech/Sheet/Tole</b> Werkstoff: Quality: Matière: <b>TYPE 316 / 316 L</b>		Lieferbedingungen/Terms of delivery/Conditions de livraison: <b>ASTM A 240/A 240M-04a</b> <b>ASME SA 240 Sec.II Part A Ed.04</b> <b>ASTM A 480/A 480M-04 ASME SA 480/SA-480M 01</b> <b>ASTM A 666-03</b> <b>SAE AMS 5507 F</b> <b>SAE AMS 5524 K</b>								
Position Item Poste	Stückzahl Quantity Montre	Gewicht/Masse Mass LBS	Maße/Produkt dimensions/Dimensions du produit Inch			Erzeugnis-Nr. Prod. No. Mode de liv.	Schmelz-Nr. Cast-No. Coulée N°	Lot-/Bund-Nr. Lot-/Cob-No. Lot/Releau-N°	Ausführung Finish Fini	
10	629	36953	0,0350 x 48,0000 x 120,0000			AOD		22056	3C2B	
Schmelz-Nr. Cast-No. Coulée N°	C %	Si %	Mn %	P %	S %	Cr %	Mo %	Ni %	N %	Cu %
484447	0,02	0,37	0,86	0,029	0,001	16,85	2,02	10,54	0,037	0,23
Probe Number Test No. Essai N°	Lot-/Bund-Nr. Lot-/Cob-No. Lot/Releau-N°	Rp0.2 PSI	Rp1% PSI	Rm PSI	A2° %	HV	KO	GL/BT %		
596 A	22056 00	47555	51325	91195	49,8	163,0	10,0	17,0		
596 E	22056 00	48135	51760	91920	50,0	164,0	10,0	17,0		
Probentyp zur Werkprüfung	KO Korngröße / Grain Size nach ASTM E 112 GL/BT Glanz bei 20 Grad (BRIGHTNESS TEST=USA) <b>QUER</b>									
Verwechslungsprüfung (Spektralanalyse)/Test of identity (spectrum analysis)/Contrôle d'identification (analyse spectrale) Maße - Oberfläche/Dimensions - Surface/Dimensions - Surface Prüfung auf Interkrist. Korros./Test of intercryst. corros./Test de corros. intercryst.								I.O. I.O. O.B.		
<b>ThyssenKrupp Nirosta GmbH</b> DIESES ZEUGNIS WURDE VOM RECHNER ERSTELLT WERK KREFELD, ABNAHME BUTZEN ABNAHMEBEAUFTRAGTER INSPECTION REPRESENTATIVE TEL:02151-832447 FAX:02151-834106								Frei von Quecksilber / free of mercury NO WELD REPAIR WÄRMEBEHANDLUNG : 1050 GRAD C / LUFT TRAITEMENT TERMIQUE : 1050 GRAD C / AIR HEAT - TREATMENT : 1050 DEGREE / AIR		
								8892721 8892723 8892741 8892747 8892748 8892749 8892750 8892760 8892762 8892763 8892765		

# 484447

2099

48" x 120"

316

SHEET

